Work Orde		20944	*120944*								_	Page 2	1
Revision ID:	D3436-5 Bushing			Accept	*N <u>9</u> 00	<u>040</u>	100)*	Setup St	art top		S1* S2*	
Start Date: Required Date: Reference:	6/16/14	Start Qty: 24.00 Req'd Qty: 24.00	*94* *94*		Cust Item 1 Customer:	ID:							-
Approvals:	Process Pl	an: _ 凡しブ	Date: 14-66-	Tooling:	D	ate:	_]		art	*N	R1*	
f	QC:		Date:	SPC (Y/N):	D	ate:			St	ор	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	
Draw Nbr	Re	vision Nbr											
D3436	Re	v A											
100		Hardinge CNC LATHE	SMALL	0.00				24	Ø			DAS 44 9-89	- 1/06e/1
Hardinge	· · · C · · · · 11	Memo	E.F. EASOC AND D	0.00									
Hardinge CNC Lath	ie Sman		Folio FA526 and Dwg D									D46	
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00								DAS 44 9-89	1/06/1
110 QC Quality Control		Мето		0.00				<u> 24</u>	<u>¢</u>			9-89	4/06/1
												6 2	
120 *120*		QC8- Inspect parts - seco	ond check	0.00								ero Irl-	6-17
QC		Memo		0.00									- *

0.00

Memo

Quality Control

DQA:			Date:											TAACT
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		/ork Order u	adata anly	\Box	AEROSPACE
QA Closed.			Date.					<u> </u>		V	ork Order up	date only		
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
						Rework			Skid-tube	Crosstube	7	Water Jet	☐ E	ingineering
Part N	ο.					Scrap		Ì	Machining	Small Fab	Pro	d. Eng. Coor.	П	Quality
					_	Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	o					Suspected Unapproved			Large Fab	Composite		Supplier		
	- 1							<u> </u>					· 	
Root			_		Desci	ription of work order update	ı	Initial	Acti		Sign &	_		
Cause	_	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verificatio	n	QC Inspector
Design						·								
Doc/Data	4													
Equip/Tooling	-													
Handling/Pre	-													
Material Operator														
Offset/Setup	\dashv													
Process	\dashv													
Supplier	┪													
Training	7													
Transport	ヿ													
Unapproved .														
لأيمر							FA	ULT CA	TEGORY	_				
Lańdiń	g Ge	ear	·			General		_	-		_			
	E	Bending				Bend		Folio/F	Program	<u></u>	Outside Dim	ensions	Pre	ssure/Forced
	<u></u>	Centre No	t Concen	ntric		BOM/Route		Grain			Over/Under	tolerance	⊢—	t-up
.]	— 1	Cracks				Broken/Damage/Defect		Hardwa		_	Part Incorred		Ter	mperature/Cure
, , ,	_		ık/Ripple,	/Wave		Burrs		4 ·	ion Incomplete/Un	· –	Part Lost/Mi	ssing	∭We	
	_	Cuffs				Contamination	<u> </u>	4	tions Incomplete/U	nclear	Part Moved		Ŭ Wr	ong Stock Pulled
<u> </u>	_	Crushing				Countersink	_	-1	gned/off center		Positioned V	-		
-	_	leat Trea				Cut Too Short	_	Mislabe			Power Loss/	Surge	Oth	ner
	_		n Strip in	Tube		Drawing	_	Misread						
	_	Marks/Ch			<u> </u>	Drill Holes		Off-set						
-	_	Turning So				Finish	_	-	Calibration -					
		Vave/Tw	ist in Tub	e		Fit/Function	l	Out of S	Sequence					

Work Ord June-16-14 1:.		120944		*120	944*							Page 2
Item ID: Revision ID: Item Name:	D3436-5 Bushing	5		Accept	*N900	<u>ი</u> 40	100	ገ*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	6/16/14 e: 6/16/14	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I Customer:	D:						
Approvals:	Process QC:	s Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description Identify as per dwg & Sto	CO	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Packaging Packaging		Memo ****STOC	K IN LARGE FAB****	0.00				VY I	ł —	/	Y -	DA 26 9-8

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

MLJ 1406-19

DQA:			_ Date:			_								TOACT
04.61			Data:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		rad Oak			AEROSPACE
QA Closed:			Date:					r		w	ork Order up	date only		·
Work Orde	er:					DISPOSITION								
	-					Rework		İ	Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	Vo.					Scrap		Ì	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	_					Use-as-is		1	noforming	Finishing	⊣	re/Packaging		Other
NCR N	۷o					Suspected Unapproved	1		Large Fab	Composite]	Supplier		
			,	ı				<u> </u>	,					
Root				_	Desci	ription of work order update		Initial	Actio		Sign &			
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	<u> </u>	QC Inspector
Design	Щ													
Doc/Data	Н													
Equip/Tooling	Щ													
Handling/Pre	Щ													
Material	Н													
Operator	Н													
Offset/Setup	Н													
Process	Н					:								
Supplier	H													
Training	Н					ı						,		
Transport	Н													
Unapproved			L				EAI	UT CAT	L TEGORY	-	1			
Landi	na G	ear				General	IA	OLI CA	ILGONI					
Zanan		Bending				Bend		Folio/P	rogram	Ī	Outside Dim	ensions I		Pressure/Forced
:	-	_	ot Concer	ntric		BOM/Route	_	Grain	. ogra		Over/Under		_	Set-up
	-	Cracks	0011001	10,10		Broken/Damage/Defect		Hardwa	ire		Part Incorred		-	Temperature/Cure
	—		nk/Ripple	/Wave		Burrs	\vdash	1	ion Incomplete/Unq	nualified	Part Lost/Mi			Weld
	-	Cuffs		,		Contamination	<u> </u>	1	ions Incomplete/Un	· —	Part Moved			Wrong Stock Pulled
	-	Crushing				Countersink		4	ned/off center		Positioned V	ا Vrong		2 G = #11 / #11 #4
	-	Heat Trea	at			Cut Too Short		Mislabe			Power Loss/	- 1		Other
	\vdash		n Strip in	Tube		Drawing	_	Misread		<u> </u>		۱ -		
	\vdash	Marks/Ch	-			Drill Holes		Off-set				· · · · · · · · · · · · · · · · · · ·		
	\prod	Turning S	equence			Finish		Out of (Calibration			. "		
	\prod_{i}	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence					

June-16-14 1:13:55 PM

Work Order ID: 120944

120944

Parent Item:

D3436-5

D3436-5

Parent Item Name: Bushing

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP A05.05.11New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.373W.049		Purchased	No			100	f	8.0000	0.1083	2.736			
***********	TO 070\A	1040*			•		•		**				

M4130NT0 373W 049

4130 RD tube .373 x .049W

Loc Qty Loc Code Location MAT032 122760 8

DQA:		Date:										TAART
					WORK ORDER NON-	-C(ONFO	RMANCE / UP				AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only	
Work Orde	r:				DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
				_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		-	noforming	Finishing	-1	re/Packaging	Other
NCR N	o				Suspected Unapproved		ļ	Large Fab	Composite]	Supplier	
Root		[Desci	ription of work order update		I Initial	Acti	on	Sign &		1
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
Design							5		-			
oc/Data												
quip/Tooling												
landling/Pre	∔ 4.									1		
//aterial		ļ										
Operator												
Offset/Setup												
rocess												
upplier												
raining		-										
ransport												
Inapproved		<u> </u>										<u> </u>
						FA	ULT CA	TEGORY	<u> </u>			
Landin	g Gear			_	General	_	1		_	7		-
	Bending			-	Bend		- i	Program	<u> </u>	Outside Dim	<u> </u>	Pressure/Forced
<u> </u>	Centre No	ot Conce	ntric	\vdash	BOM/Route		Grain		<u> </u>	Over/Under	—	Set-up
1	Cracks			_	Broken/Damage/Defect	\vdash	Hardwa			Part Incorre	<u> </u>	Temperature/Cure
	Crimp/Kir	ık/Ripple	e/Wave	-	Burrs	-	1 .	ion Incomplete/Un	· —	Part Lost/Mi	issing	Weld
	Cuffs			<u> </u>	Contamination	\vdash	-1	tions Incomplete/U	nclear	Part Moved	L	Wrong Stock Pulled
<u> </u>	Crushing			<u> </u>	Countersink	<u> </u>	-1	gned/off center		Positioned V	_	7045
}	Heat Trea		T1	<u> </u>	Cut Too Short	_	Mislabe			Power Loss/	surge	Other
	Inspection	•	lupe	<u> </u>	Drawing	\vdash	Misread					
-	Marks/Ch			-	Drill Holes	 	Off-set					··
	Turning S	-			Finish	\vdash	4	Calibration				
	Wave/Tw	ist in Tul	pe.		Fit/Function	<u></u>	Jout of S	Sequence				

DART AEROSPACE LTD	Work Order: 120944	
Description: Bushing	Part Number: D3436-5	
Inspection Dwg: D3436 Rev: A	Page 1 of 1	

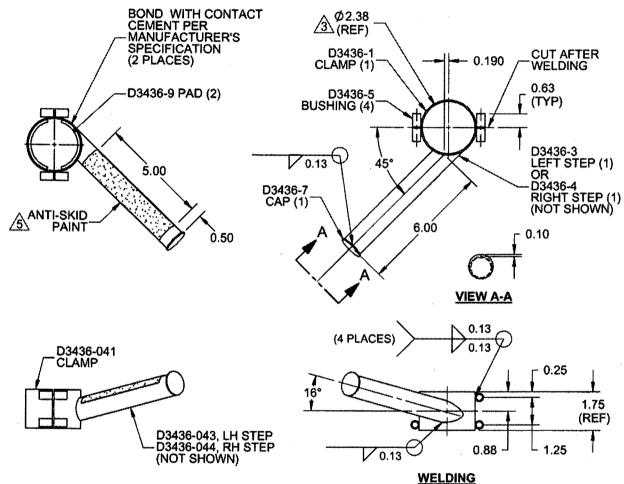
	FIRS	T ARTICLE II	NSPECTI	ON CHE	CKLIST		
	X	First Arti	icle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
1.26	+/-0.030	10261	7		FROH	Venh	•
Ø0.38	+/-0.030	377	7		h	n	
0.049	+/-0.010	.047	7		in	, h	
· · · · · · · · · · · · · · · · · · ·					<u> </u>		
	DAS		60-6				
Measured by:	44 9-89	Audited by:	Sya		Prototype	Approval:	N/A
Date:	14/06/17	Date:		17		Date:	N/A
Rev Date A 05.07.07	Change New Issue				F	Revised by CJ/JLM	Approved



DESIGN N	1B	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	E W	APPROVED #	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE	05.0)4.28	MAINTENANCE STEP	SCALE 1:4
Α	0	5.04.28	NEW ISSUE	

RELEASED

05.05.27



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NOTES:

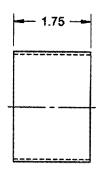
POSITION PARTS AS PER JIGS DT8772 AND DT8773
) WELD PER DART QSI 004
) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
| APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
| TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

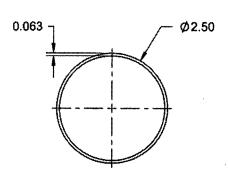
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DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED #	D3436	REV. A SHEET 2 OF 4
 DATE 05.0)4.28	MAINTENANCE STEP	SCALE 1:2

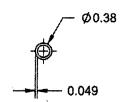




D3436-1 CLAMP

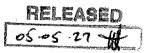
1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



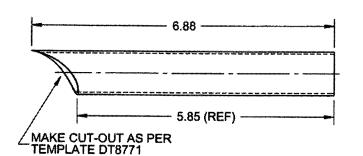
D3436-1/-5, GENERAL NOTES:

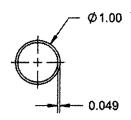
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4				
DATE	······································	TITLE	SCALE				
05.0)4.28	MAINTENANCE STEP	1:2				

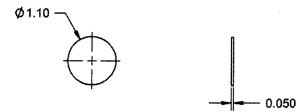




D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

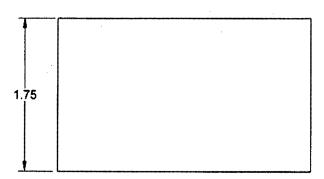
D3436-3/-7, GENERAL NOTES:

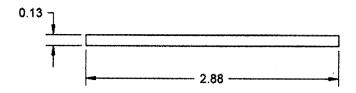
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

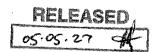
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CHECKED	APPROVED #	DRAWING NO.	REV. A SHEET 4 OF 4
DATE 05.0)4.28	MAINTENANCE STEP	SCALE 1:1







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S.125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES

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